

May-07-15 2:45:45 PM

132469

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: D2940-1 Turning Detail

Start Date: 5/07/15 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 5/07/15 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: _____ **Process Plan:** NA **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSK081	B

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA079

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

 $\dot{O}C$

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

OC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 132469

132469

Page 2

May-07-15 2:45:45 PM

Item ID: DSK081

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2940-1 Turning Detail

Start Date: 5/07/15 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					5			215611
Packaging	Memo	0.00							
Packaging	LOCATION: MAT060								
140		0.00							
140	QC21- Final Inspection - Work Order Release					ML5		JUN 15 2015	
QC	Memo	0.00							
Quality Control									

ML5 JUN 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

May-07-15 2:45:45 PM

Page 1

Work Order ID: 132469

132469

Parent Item: DSK081

DSK081

Parent Item Name: D2940-1 Turning Detail

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-007		Manufactured	No				Each	0.0000		5			

D6104-007

Round Billet, 17-4

B131886

**

JFL 2015-06-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 132469
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.214	3.214	3.214	3.214	3.214
B	4.946	4.966		4.957	4.957	4.957	4.957	4.957
C	0.718	0.738		0.728	0.728	0.728	0.728	0.728
D	0.090	0.110		0.100	0.100	0.100	0.100	0.100
E	3.564	3.584		3.576	3.576	3.576	3.575	3.575
F	0.022	0.042		0.032	0.032	0.032	0.032	0.032
G	3.444	3.464		3.455	3.455	3.455	3.454	3.455
H	0.112	0.132		0.122	0.122	0.122	0.122	0.122
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		0.423	0.423	0.423	0.423	0.423
L	0.913	0.933		0.922	0.922	0.922	0.922	0.922
M								
N								
O								
P								

Measured by: JFC **Date:** 2015-06-10

Audited by: JL **Date:** 15-6-11

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	